

Date: Tuesday, 10/2/2007 10:44:01 AM
 User: Kim Johnston

Process Sheet

44

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPAD |
| Job Number : 34943 | |
| Estimate Number : 12712 | |
| P.O. Number : | Part Number : D35371 |
| This Issue : 10/2/2007 S.O. No. : | Drawing Number : D3537 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : C |
| Previous Run : 34282 | Material : |
| Written By : | Due Date : 10/30/2007 |
| Checked & Approved By : <u>10710.02</u> | Qty: <u>125</u> Um: Each |
| Comment : Est Rev: A New Issue 07-02-14 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



10.0076



Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)
 M304S16GA .063" 304 SS SHEET
 Batch: 105130 107-10-9

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3537
 Dwg Rev: C 107-10-9
 Prog Rev: C
 2-Deburr if necessary 107-10-9

125

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



107-10-9



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

107-10-9 125

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
 2-Identify as D3537-1

107-10-9 125

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:44:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 34943

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

M105599/M106036 FC/28

07/10/26

125x

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-29

125

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters 07/10/29

125

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642

07-10-31

125

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/31

125X

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR17

BR 07-10-31

125

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31

Job Completion



07-10-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

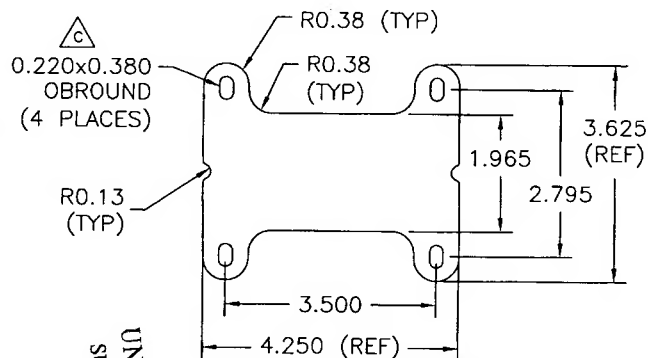
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

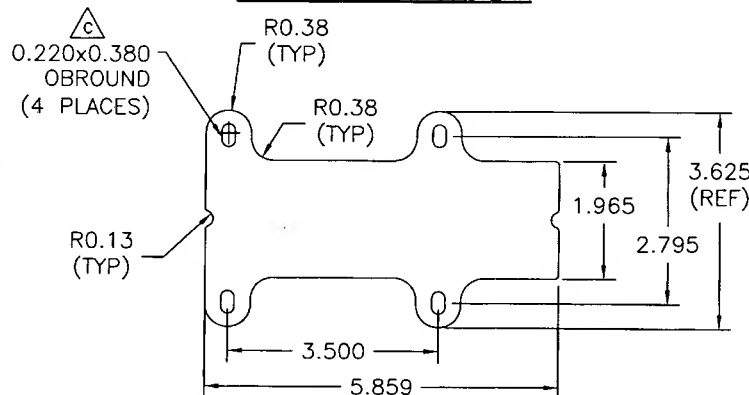
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

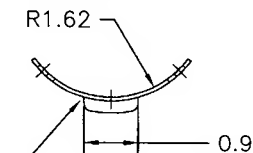
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

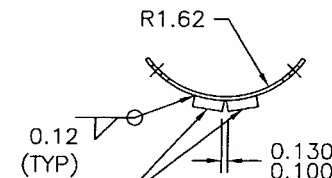


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

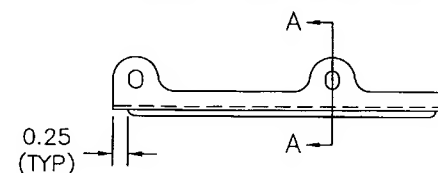
SECTION B-B



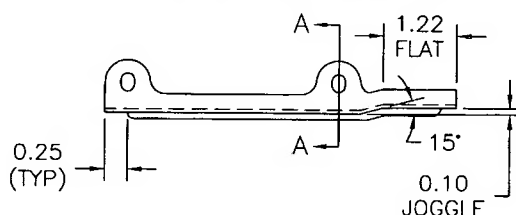
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 AM
per ECN 962

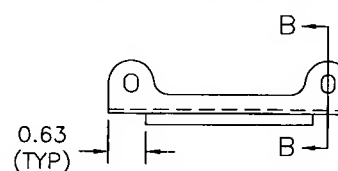
D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



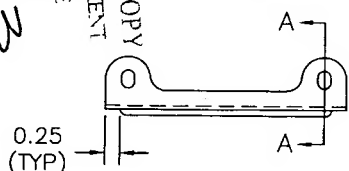
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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| | | |
|--------------|----------|----------------------------------|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | CB | DRAWN BY PH |
| CHECKED | # | APPROVED # |
| DATE | 07.04.13 | TITLE WEARPAD |
| DRAWING NO. | D3537 | REV. C |
| SHEET 1 OF 1 | | SCALE 1:2 |

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PORT HADLOCK, OH

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